

Work Order ID 150750

Thursday, September 01, 2016 8:57:23 AM

150750

Page 1

Item ID: D205-523-013 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Heli-Rappel™ 500 lbs, Fits LH or RH
Start Date: 9/1/2016 Start Qty: 3.00 ***3*** Cust Item ID:
Required Date: 9/8/2016 Req'd Qty: 3.00 ***3*** Customer:
Reference:

Approvals: Process Plan: **DAS 21 9-89** Date: **SEP 01 2016** Tooling: Date: Run Start ***NR1***
QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
DSI9301	Rev A	DAS 21 9-89	SEP 01 2016			DAS 21 9-89		16-09-01	(3)
100	Document Control	0.00				DAS 27 9-89			
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy blue file & type labels as per PPP D205-523-013, CHG 002								
						SEP 07 2016		SEP 07 2016	
110	Pick Kit	0.00				(3)	PC	DAS 28 9-89	SEP 07 2016
110									
Packaging	Memo	0.00							
Packaging									
120	QC4- 100% Inspect kits for completeness	0.00				DAS 27 9-89			
120									
QC	Memo	0.02							
Quality Control						SEP 07 2016			

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

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Accept

N900040100

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NS1

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NS2

Item Name: Heli-Rappel™ 500 lbs, Fits LH or RH

Start Date: 9/1/2016 Start Qty: 3.00

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Required Date: 9/8/2016 Req'd Qty: 3.00

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

130

Packaging

Packaging

Memo

Package as per PPP D205-523-013
Location : FG018

0.00

Identify and Stock

X3

DAS
27
9-89
DAS
28
9-89

SEP 07 2016

140

140

QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.05

DAS
21
9-89

SEP 07 2016

DAS
21
9-89

SEP 07 2016

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Picklist Print

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Page 1

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150750

Parent Item: D205-523-013

D205-523-013

Parent Item Name: Heli-Rappel™ 500 lbs, Fits LH or RH

Start Date: 9/1/2016

Required Date: 9/8/2016

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP B02.04.04Updated Drawing and Added Inspection Level 21SM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D205-523-043 *D205-523-043* Slide Bar Assembly DAS 27 9-89		Manufactured	No			110	Each	0.0000	1	3		DAS 28 9-89	
D2224 *D2224* Rappel Anchor Assembly DAS 27 9-89		Manufactured	No			110	Each	4.0000	1	3		PC	
				<u>Location</u>				<u>Loc Qty</u>					
				ST004				4					
				123383				4		6			
D2229 *D2229* Doubler DAS 27 9-89		Manufactured	No			110	Each	8.0000	2	6		PC	
				<u>Location</u>				<u>Loc Qty</u>					
				ST004				8					
				140989				8		6			
AN5-14A *AN5-14A* Bolt DAS 27 9-89		Purchased	No			110	Each	26.0000	4	12		PC	
				<u>Location</u>				<u>Loc Qty</u>					
				ST338				26					
				m133990				1					
				m134943				25		12			

SEP 07 2016

DQA: _____ Date: _____

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Page 2

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Parent Item: D205-523-013

D205-523-013

Parent Item Name: Heli-Rappel™ 500 lbs, Fits LH or RH

Start Date: 9/1/2016

Required Date: 9/8/2016

Start Qty: 3.00

Required Qty: 3.00

MS21042L5

Purchased

No

110

Each

621.0000

4

12

MS21042L5

Nut

PC

DAS
28
9-89

Location

Loc Qty

Loc Code

GA

67

m127813

67

OVER007

200

m135297

200

ST303

354

m135058

54

m135442

100

m135470

100

m135544

100

12

DAS
27
9-89

NAS1149D0563J

Purchased

No

110

Each

1,224.000

8

24

NAS1149D0563J

Washer

PC

DAS
28
9-89

Location

Loc Qty

Loc Code

GA

117

m125807

2

m133769

115

ST260a

600

m135470

600

ST263

408

m134497

4

m135058

404

ST269

99

m128257

99

24

DAS
27
9-89

SEP 07 2016

DART

DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>HA</i>	APPROVED <i>HA</i>	DRAWING NO. DSI 9301	REV. A SHEET 1 OF 1
DATE 05.05.11		TITLE RAPPEL ANCHOR INSTALLATION	SCALE NTS
A	05.05.11	NEW ISSUE	

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D205-523 REV. F

REF. CANADIAN STC: SH96-90 ISSUE 3

REF. FAA STC: SR00511NY, SR00512NY, SR00513NY

It has come to DART's attention that in general, AN5-13A bolts are a more suitable length for installation of the D2224 Rappel Anchor (ref) in place of the AN5-14A bolts referred to in D205-523 Rev.F.

It is acceptable to install the D2224 Rappel Anchor (ref) using longer or shorter AN5 bolts as needed to suit the thickness of the rotorcraft's ceiling panel. It is acceptable to use a light AN960JD516L washer under the head of the bolt instead of an AN960JD516 washer per D205-523 Rev. F. However, to preserve the structural integrity of the system, the washer under the MS21042L5 nut must remain an AN960JD516 washer.

For all cases, ensure the bolts properly secure the D2224 Rappel Anchor (ref) to the rotorcraft's ceiling and each bolt has at least 2 threads in safety.

SHOP COPY
RETURN TO
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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 150450 M/S
1609-01

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: *D. Shepherd*
D. SHEPHERD (DE # 02)

DATE: 05.05.11
CERT. NO.: SH96-90
ISSUE NO.: 3

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REFERENCE ONLY

4. WEIGHT AND BALANCE

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D205-523-013	3.5 lb 1.59 kg	±34.5 in ±0.876 m	±120.75 in-lb ±1.39 m-kg	116.8 in 2.97 m	408.8 in-lb 4.72 m-kg

5. PARTS LIST

-013	-043	Part No.	Description
X		D205-523-013	HELI-RAPPEL™ INSTALLATION
1	X	D205-523-043	SLIDE BAR ASSEMBLY
	1	D3011-1	RAPPEL SLIDE BAR
	2	33116	STUD FITTING
	2	MS21042L6	NUT (OR MS21042-6)
	2	AN960JD616	WASHER
	2	D3012-1	DECAL
	2	D3012-3	DECAL
	2	D3012-5	DECAL
1		D2224	RAPPEL ANCHOR
2		D2229	DOUBLER
4		AN5-14A	BOLT
8		AN960JD516	WASHER
4		MS21042L5	NUT (OR MS21042-5)

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Revision: F

Date: 01.03.29